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D3172-041
Job Sheet 166632



Part No: D3172-041

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/12/17

Job Tracking No:

Due Date: 10/27/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV D IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D 11.04.04 added pressure wash DD VERF:EC IPP REV:E 16.11.03 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/25/17	0.00	0.00	Start up container	2017-10-25
100	Large Fab	1 pcs	10/26/17	0.00	25.00	Large Fab 8	2017-10-25
110	QC	1 pcs	10/26/17	0.00	0.00	QC9	2017-10-25
120	QC	1 pcs	10/26/17	0.00	0.00	QC6	2017-10-25
130	HandFinish	1 pcs	10/26/17	0.00	0.38	HandFinish2	2017-10-25
140	Powdercoat	1 pcs	10/27/17	0.00	1.04	Powdercoat1	2017-10-25
145	Packaging	1 pcs	10/27/17	0.00	0.00	Packaging3	2017-10-25
150	QC21-SA	1 Ea	10/27/17	0.00	0.00	QC21	2017-10-25

Part Op 100 - 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. 2- Drill #40 diameter hole in the center of 20.760"

Descriptions: c-bore on D3204-5 arm prior to weld 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.

140 - ***Cover holes for bushing***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2232-3	2	10	0	0
	D2327-3	2	18	0	0
	D2581	2	32	0	0
	D3166-1	4	12	0	0
	D3174-1	8	11	0	0
	D5365-1	4	4	0	0
	M304EX0.75-16F	48	354	0	0
	M304TS0.750W.065	51	218	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Wo

W I P

Date

PART NO: D3172-041**Revision:****Operation: Start up Operation****Quantity: 1****Next Op: 100 Large Fab****Basket Base Assembly****SERIAL NO: S000604****Job #: 166632****Mfg Date: 10/16/17****OCT17**

AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

FAULT CATEGORY

Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Contamination	☐	Out of Sequence	☐	Part Moved	☐
Countersink	☐	Off-set	☐	Drawing	☐
Cut Too Short	☐	Mislabeled	☐	Finish	☐
Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER :